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Run	Start	*NR1*
	Stop	*NR2*

100		0.00		
100				
Waterjet	Memo	0.03	(4)	22/11/10/22
FLOW CNC Waterjet	1-Cut as per Dwg D3847			
	Dwg Rev: <u>D</u>			
	Prog Rev: <u>D</u>			
	2-Deburr if necessary			
110	QC2- Inspect parts off machine FAI/FAIB	0.00		
110				
QC	Memo	0.01	(4)	22/11/10/22
Quality Control				

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Item ID: D3847-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 10/28/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/2/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Weld per dwg & QSI004 4.5	0.00							
150									
autoweld 1	Memo	0.00							
Automated Welding 1	Weld hardcoat as per dwg A/R 8259 Batch: <u>M125051</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.01							
Quality Control									
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
NOV 04 2016DAS
38
9-89
NOV 04 2016

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Item ID: D3847-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 10/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/2/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.07							
Quality Control									

16/11/8 *[Signature]*

[Signature] 16-11-8

Picklist Print

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Work Order ID: 151985

151985

Parent Item: D3847-11

D3847-11

Parent Item Name: Wearpad

Start Date: 10/28/2016

Required Date: 11/2/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
16.03.31 AS PER DWG REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	94.8700		0.712842			

M304S16GA

304/316 Sheet .063

see 11/10/22

Location

Loc Qty

Loc Code

MAT010

94.87

m135377

28.42

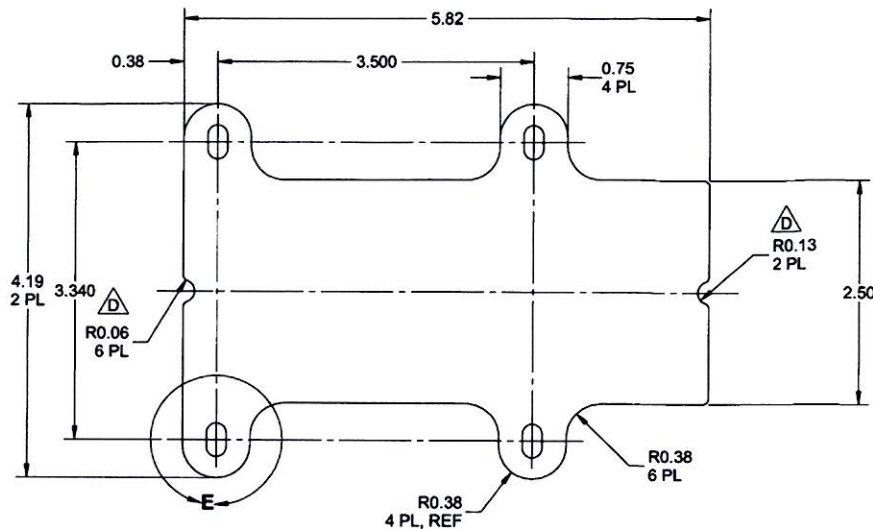
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2.45

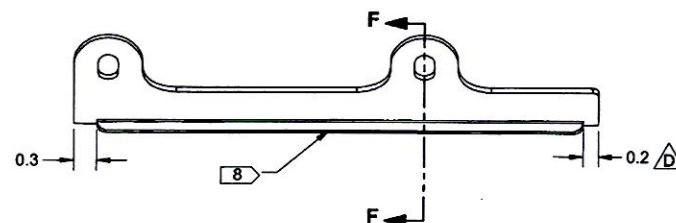
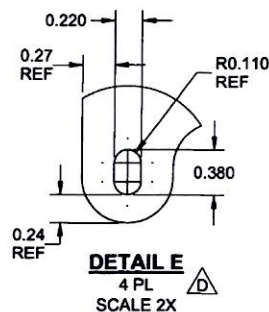
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64

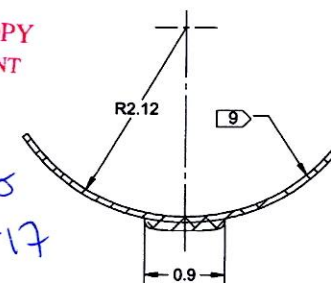
3



D3847-11F WEARPAD
(FLAT PATTERN)



D3847-11 WEARPAD
(MAKE FROM D3847-11F)



SECTION F-F

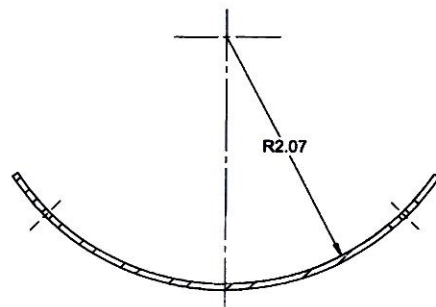
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151985
MLJ
161017

- NOTES:**
- 1) MATERIAL -11F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.43 lbs
 - 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK; PER DART QSI 005 4.9

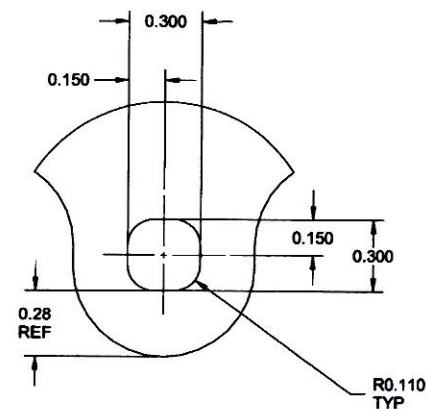
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SECTION C-C
SCALE 4X
C3-2
C4-3
C3-4
C2-5



DETAIL D
SCALE 4X
B5-2
B6-3
B3-4
B4-5

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